

Date: Thursday, 23/04/2009 3:32:53 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FUEL PURGE CANISTER INSTALLATION
Job Number :	47454		
Estimate Number :	10856		
P.O. Number :		Part Number :	D412706011
This Issue :	23/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	//	Project Number :	N/A
Previous Run :	40626	Drawing Revision :	N/A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	05/05/2009
Written By :		Qty:	2 Um: Each
Checked & Approved By :	JLD 09.04.24		
Comment :	Est Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM Est Rev:F 08-05-14 revise comment in seq.17 /24 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 09/05/11



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-706-011CHG001

5 09/15/25

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D20014	Valve Assembly (1/4")
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X



50

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2001-4

Valve Assembly

1346811

9/15/22

50

4.0	D3262041	Canister Assembly
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41823

2x

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3262-041

Canister Assembly

43642

9/15/25

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 47454

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32641

Bracket

X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3264-1

Bracket

15471338

9/5/21

SP

6.0

D329710098

HOSE ASS'Y

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-1-0098

Hose Assembly

210640

9/5/21

SP

7.0

D329730085

HOSE ASS'Y

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-3-0085

Hose Assembly

1543652

9/5/21

SP

8.0

D329730210

HOSE ASS'Y

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-3-0210

Hose Assembly

1540641

9/5/21

SP

9.0

D3298001

Tube Assembly

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-001

Tube Assembly

47421

9/5/21

SP

10.0

D3298003

Tube Assembly

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-003

Tube Assembly

1543654

9/5/21

SP

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3298005

Tube Assembly

X



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-005

Tube Assembly

1242655

9/5/22

SP

12.0

D3298007

Tube Assembly

X



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-007

Fitting

40612

9/5/22

SP

13.0

D3298009

Tube Assembly

X



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-009 Tube Assembly

46645

9/5/22

①

47300

SP

14.0

D32991

Fitting

X



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-1

Fitting

1541828

9/5/22

SP

15.0

D32993

Fitting

X



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting

1541829

9/5/22

SP

16.0

D32995

Fitting

X



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Fitting

1240302

9/5/22

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D412706011

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 D33011 Placard

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3301-1

Doubler B343658

7/5/22

50

18.0 D33013 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3301-3

Placard B341170

9/5/22

50

19.0 D33021 Doubler

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3302-1

Doubler B339847

9/5/22

50

20.0 D33023 Doubler

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3302-3

Doubler B339848

9/5/22

50

21.0 D33291 Bushing

X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D3329-1

Bushing B334218

9/5/22

50

22.0 AN35A Bolt

X



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN3-5A

Bolt M15205

9/5/22

50

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47454

Part Number: D412706011

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN8146D

Plug

X



①



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

1 AN814-6D

Description

Plug

Batch

M107376

M109068

9/5/22

SP

24.0

AN8156D

Union-M-Flare

X



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

3 AN8156D

Description

Plug

Batch

M111650

9/5/22

SP

25.0

AN8326D

UNION

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

1 AN832-6D

Description

Union

Batch

M107737

9/5/22

SP

26.0

AN8336D

Elbow, Bulkhead-M-Flare

X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

2 AN833-6D

Description

Union

Batch

M109068

②
M111454

9/5/22

SP

27.0

AN9246D

Nut

X



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

5 AN924-6D

Description

Nut

Batch

M108701

9/5/22

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 47454

Part Number: D412706011

Job Number:



Seq. #: Machine Or Operation: Description :

28.0 AN9386D Tee



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN938-6D

Tee

M1101925

9/5/22

SP

29.0 AN960JD10 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M1111279

9/5/22

SP

30.0 AN960JD10L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD10L

Washer

M118235

9/5/22

SP

31.0 MS21042L3 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3 Nut (or -3)

M110844

9/5/22

SP

32.0 MS21919WDG9 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21919WDG9

Clamp

M1109174

9/5/22

SP

33.0 MS2192042 CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M111611

9/5/22

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

MS287786

Packing



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

10 MS28778-6

O-Ring

M111359

9/5/22

SP

35.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 MS35489-11

Grommet

M109166

9/5/22

SP

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/05/25

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-706-011

Location:

PPP Rev:

3/11
B

9/5/25

SP

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



MF 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries